

**AMENDMENTS TO THE CLAIMS:**

This listing of claims will replace all prior versions, and listings, of claims in this application.

**Listing of Claims**

1. (Currently Amended) Machining method of a last (1) for the production of shoes, which comprises the rough-hewn, piercing, identification marking, and removal of the surpluses (4, 5) operations resultants of the rough-hewn operation, ~~characterized in that it comprises~~ comprising the following steps:

a) Manual positioning of the last (1) in a machining center by numerical control (10), fixing it by fitting the last in housings (2, 3) in the surpluses (4, 5) located in the heel-pad and in the toe of the last (1) and first movable fastening means (11a, 11b) in the machining center (10).

b) Piercing and identification marking of the last (1) by a drill (15) of the machining center (10), the last (1) being held and positioned by said first movable fastening means (11a, 11b).

c) Manual removal of the last (1) from the first movable fastening means (11a, 11b) and manual fastening of it to second movable fastening means (19, 20) in the machining center (10) that introduces inside holes (6a, 6b) made previously in the last (1) in the step of piercing and identification marking.

d) Removal by automatic machining, by means of the drill (15), of the surpluses (4, 5) that have been left free.

2. (Currently Amended) Method, according to claim 1, ~~characterized in that~~ wherein the operation piercing of the last (1) comprises the machining of a plurality of holes (6d) in the sole of the last (1), a hole (6c) in the instep shoulders, and other two holes (6a, 6b) of different diameter in its upside.

3. (Currently Amended) Method, according to claim 2, ~~characterized in that~~ wherein the positioning operation of the last (1) for its piercing and its identification marking is carried out rotating the last (1) by means of the first movable fastening means (11a, 11b).

4. (Currently Amended) Method, according to claim 2 ~~the claims 2 or 3~~, ~~characterized in that~~ wherein the removal process of the surpluses (4, 5) is carried out fixing the last (1) by the two holes of different diameter (6a, 6b) made in its upside to the second movable fastening means (19, 20).

5. (Currently Amended) Method, according to claim 4, ~~characterized in that~~ wherein the positioning of the last (1) in the removal step of the surpluses (4, 5) is carried out rotating it by means of the second movable fastening means (19, 20).

6. (Currently Amended) Method, according to ~~anyone of claims~~ claim 1 to 5, ~~characterized in that~~ wherein the first movable fastening means (11a, 11b) fix the last (1) on an horizontal position and the second movable fastening means (19, 20) fix the last (1) on a vertical position.

7. (Currently Amended) Method, according to claim 6, ~~characterized in that~~ wherein the turn of the last (1) by the first movable fastening means (11a, 11b) and by the second movable fastening means (19, 20) is carried out about an horizontal axis.

8. (Currently Amended) Machining center by numerical control (10) for piercing, identification marking, and removal of the surpluses (4, 5) resultants of a previous rough-hewn process of a last (1) for the production of shoes, ~~characterized in that~~ wherein it comprises a plurality of drills (15, 17), first movable fastening means (11a, 11b) for their fitting in housings (2, 3) in the surpluses (4, 5) located in the heel-pad and in the toe of the last (1), and second movable fastening means (19, 20) for their introduction inside holes (6a, 6b) made in the last (1) by a drill (15).

9. (Currently Amended) Center (10), according to claim 8, ~~characterized in that~~ wherein the first movable fastening means (11a, 11b) comprise a first support (11b) for their fitting in the housing (3) of the surplus (5) of the heel-pad of the last (1), and a second support (11a) for their fitting in the housing (2) of the surplus (4) of the toe of the last (1), both supports (11a, 11b) being able to vary their angle and being able to rotate about the first support (11b) about their own axis.

10. (Currently Amended) Center (10), according to claim 9, ~~characterized in that~~ wherein the second support (11a) can rotate on their own axis.

11. (Currently Amended) Center (10), according to claims 9 ~~or 10~~, ~~characterized in that~~ wherein the second support (11a) is fixed to means (13, 14) for its height and depth regulation for the correct fastening of lasts (1) of different sizes and types.

12. (Currently Amended) Center (10), according to claim 11, ~~characterized in that~~ wherein the height regulation means comprise an endless screw (14) which can be operated by a rotatory handle, and the depth regulation means comprise a pneumatic cylinder (13) which can be operated by a manual handle.

13. (Currently Amended) Center (10), according to ~~anyone of claim 9 to 12~~, ~~characterized in that~~ wherein the supports (11a, 11b) include a pair of protrusions (12) complementary to the housings (2, 3) of the surpluses (4, 5) of the last (1).

14. (Currently Amended) Center (10), according to claim 8, ~~characterized in that~~ wherein the second movable fastening means (19, 20) comprise an arm (18), which can rotate about an axis, which includes two cylinders (19, 20) of different diameter, the cylinder of greater diameter (20) including pressing means against the walls of the hole (6a) of the last (1) in which is housed.

15. (Currently Amended) Center (10), according to claim 14, ~~characterized in that~~ wherein the pressing means comprise a hollow shaft (21) whose external walls present a cross-section change (22), which houses inside it a piston (23) of a pneumatic cylinder (24), said piston (23) being connected on its end to a head (25) provided with a skirt which includes flexible wings (26), so that when the piston (23)

strikes back, it forces the head (25) to travel over the external walls of the shaft (21), so that it arrives to the cross-section change (22) the wings (26) are expanded, against the walls of the hole (6a) of the last (1).

16 (Currently Amended) . Center (10), according to ~~claims~~ claim 8 to 15, characterized in that wherein the drills (15, 17) are interchangeable.